

Friday, March 10, 2017 2:06:17 PM

158110

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: GPS Receiver Gimbal Mount

Start Date: 3/13/2017 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 3/14/2017 **Req'd Qty:** 1.00

1

Customer:

Reference: SCHEDULED

Approvals: _____ **Process Plan:** _____

Date: MAR 10 2017**Tooling:**

Date: _____

Run Start *NR1*

QC:

Date: _____ **SPC (Y/N):** _____

Date:

Stop ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

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158110

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

1

Cust Item ID:

Start Date: 3/13/2017 **Start Qty:** 1.00

Required Date: 3/14/2017 **Req'd Qty:** 1.00

1

Customer:

Reference: SCHEDULED

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

0.00

120

Packaging

0.00

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D412-758-015
Location: FG023

Sold

DAS
27
9-89

MAR 14 2017

0.00

130

QC21- Final Inspection - Work Order Release

0.02

QC

Memo

Quality Control

DAS
21
9-RO

MAR 14 2017

DAS
21
9-80

MAR 14 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																					
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Picklist Print

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Page 1

Work Order ID: 158110

158110

Parent Item: D412-758-015

D412-758-015

Parent Item Name: GPS Receiver Gimbal Mount

Start Date: 3/13/2017

Required Date: 3/14/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.06.21 new issue DD verified by:EC
12.10.24 ECN 12-669 DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN525-10R9

Purchased

No

110

Each

170.0000

3

3

AN525-10R9

Screw

**

DAS 27 9-89
MAR 13 2017
DAS 6 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

ST329

170

m133990

170

3

D3531-041

Manufactured

No

110

Each

1.0000

1

1

D3531-041

Top Mounted Gps Bracket Assembly

**

DAS 27 9-89
MAR 13 2017
DAS 6 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

st503

1

146984

1

/

D2464

Manufactured

No

110

f

723.0577

1.1

1.157895

D2464

Neoprene Seal (\$per foot)

**

DAS 27 9-89
MAR 13 2017
DAS 6 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

ST409

723.0577380

121946

723.057738

/

cut qty of 2 at 6.6" as per dwg D2464-0066 ***per
kit***

D3525-1

Manufactured

No

110

Each

2.0000

1

1

D3525-1

Placard

**

DAS 27 9-89
MAR 13 2017
DAS 6 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

Mezz

2

140393

2

/

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Friday, March 10, 2017 2:06:23 PM

Page 2

Work Order ID: 158110

158110

Parent Item: D412-758-015

D412-758-015

Parent Item Name: GPS Receiver Gimbal Mount

Start Date: 3/13/2017

Required Date: 3/14/2017

Start Qty: 1.00

Required Qty: 1.00

D3645-1 Manufactured No

110

Each

71.0000

4

4

D3645-1

Washer

**

DAS
6
9-89

MAR 13 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST048

71

123144

71

AN525-10R10

Purchased

No

110

Each

292.0000

4

4

AN525-10R10

Screw

**

DAS
6
9-89

MAR 13 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST329

292

m135979

292

NAS1149DN632J

Purchased

No

110

Each

338.0000

4

4

NAS1149DN632.J

Washer

**

DAS
6
9-89

MAR 13 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST265

338

m134370

338

NAS1149D0363J

Purchased

No

110

Each

649.0000

7

7

NAS1149D0363.J

Washer

**

DAS
6
9-89

MAR 13 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

161

m134055

161

ST263

488

m136781

488

Friday, March 10, 2017 2:06:23 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition					
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Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
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Work Order ID: 158110

158110

Parent Item: D412-758-015

D412-758-015

Parent Item Name: GPS Receiver Gimbal Mount

Start Date: 3/13/2017

Required Date: 3/14/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L06

Purchased

No

110

Each

130.0000

4

4

MS21042L06

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

ST303

130

m136643

30

m136741

100

**

DAS
6
9-89

DAS
27
9-89

MAR 13 2017

MS24693-S29

Purchased

No

110

Each

104.0000

4

4

MS24693-S29

SCREW

DAS
28
9-89

Location

Loc Qty

Loc Code

ST286

104

m126400

4

m136741

100

**

DAS
6
9-89

DAS
27
9-89

MAR 13 2017

RAM-B-201U-A

Manufactured

No

110

Each

7.0000

2

2

RAM-B-201U-A

Socket Arm, 1.75"

DAS
28
9-89

Location

Loc Qty

Loc Code

ST570

7

144961

7

**

DAS
6
9-89

DAS
27
9-89

MAR 13 2017

RAM-B-202U

Manufactured

No

110

Each

6.0000

2

2

RAM-B-202U

Round Plate Mount, Single 1" Ball

DAS
28
9-89

Location

Loc Qty

Loc Code

ST571

6

144972

6

**

DAS
6
9-89

DAS
27
9-89

MAR 13 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Parent Item: D412-758-015

D412-758-015

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Start Date: 3/13/2017

Required Date: 3/14/2017

Start Qty: 1.00

Required Qty: 1.00

RAM-B-217U

Manufactured No

110

Each

5.0000

1

1

RAM-R-217U

Round Plate Mount, Dual 1" Ball

**

DAS
6
9-89

MAR 13 2017
DAS
27
9-89

Location

Loc Qty

Loc Code

ST571

5

144973

4

m129792

1

MS21042L3

Purchased

No

110

Each

1,354.000

3

3

MS21042L3

Nut

**

DAS
6
9-89

MAR 13 2017
DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

100

m135945

100

GA

224

m134360

102

M136665

122

OVER007

300

m134360

0

M136665

300

ST303

730

M136554

500

M136838

230

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐											
		OTHER : ☐																							

5.0 PARTS LIST

QTY -011	QTY -013	QTY -015	Part Number	Description
X			D412-758-011	Bottom Mounted GPS Receiver Gimbal Mount
	X		D412-758-013	Top Mounted GPS Receiver Gimbal Mount
		X	D412-758-015	GPSMAP Top Mounted GPS Receiver Gimbal Mount
1			D3514-041	Bottom Mounted Gimbal Assembly
	1		D3514-043	Top Mounted Gimbal Assembly
		1	D3531-041	Bracket Assy.
	2	2	D2464-0066	Neoprene Seal
1	1	1	D3525-1	Placard
1			D3527-1	Support Arm
1			D3530-1	Base Plate
1			D3530-3	Mounting Plate
1	1		D3534-1	Doubler
	4	4	D3645-1	Washer
		3	AN525-10R9	Screw
	4	4	AN525-10R10	Screw
3			AN526-632R7	Screw (or MS35206-229)
3		4	NAS1149DN632J	Washer (Alternate p/n AN960JD6)
2	4	7	NAS1149D0363J	Washer (Alternate p/n AN960JD10)
3		4	MS21042L06	Nut
1		3	MS21042L3	Nut
4	4		MS24693-S27	Screw
1			MS27039-1-09	Screw
		4	MS24693-S29	Screw
		2	RAM-B-201U-A	Socket Arm, 1.75"
		2	RAM-B-202U	Round Plate Mount, Single 1" Ball
		1	RAM-B-217U	Round Plate Mount, Dual 1" Ball

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